

# Work Order ID 62530

October 4, 2010 9:19:55 AM



Page 1

Item ID: D212-805-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Pod Modification Installation

Start Date: 10/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D212-805

A

100

0.00

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D212-601-142  
CHG001

110

0.00

Small Fab

Memo

0.00

Small Fab

1- Locate DT9667 jig on pod lid as per dwg. open holes as per dwg (1.00" holes  
is open with a hole saw)  
2- Seal all edges with cyanoacrylate glue

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

B/10-10-27  
①

ET 10-10-20 (x1)

7/10/02

# Work Order ID 62530

October 4, 2010 9:19:56 AM



Page 2

Item ID: D212-805-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Pod Modification Installation

Start Date: 10/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Small Fab

Memo

0.00

Install D4175-I pod Gps doubler (bond with sikaflex)

\*\*\*Use DT9667 jig to hold doubler in place while sikaflex cures\*\*\*

A/R Sikaflex Batch: 115 114

exp date: 11-01-01

ST

10-10-23

140

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

8/10/20/17

(XU)

150

0.00



Small Fab

Memo

0.00

1- Locate DT9668 jig on aft, inside half of rear pannel on pod as per dwg

2- Drill out holes to .191" (6 places) use bolts .1875" to hold jig in place.

3- Use router to remove inner square

4- Seal all edges with cyanoacrylate glue

ST

10-10-20

(XU)

# Work Order ID 62530

October 4, 2010 9:20:08 AM

Page 3

Item ID: D212-805-011

Accept

Revision ID:

Item Name: Pod Modification Installation

Start Date: 10/04/10 Start Qty: 1.00

Required Date: 10/15/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

0.00



Small Fab

Memo

0.00

Small Fab

Bond and bolt on D4174-1, D4174-3 connector plate and doubler using sikaflex and appropriate hardware.

A/R Sykaflex Batch: 115114

exp date: 11-01-01

RT 10-10-23

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/10/22

# Work Order ID 62530

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Page 4

Item ID: D212-805-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Pod Modification Installation

Start Date: 10/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

0.00



Small Fab

Memo

0.00

Small Fab

1- Locate DT9669 jig on outside of base on pod as per dwg. \*\*\*Orientation and groove of jig as per dwg\*\*\*

2- Open holes and seal holes with cyanoacrylate glue as per dwg and seal exposed foam core with Hysol 956 and milled fiber

A/R Hysol Batch: 113477

exp. date: 10-12-17

A/R Milled fiber Batch: 100859

3- Allow resin to cure for min. 12HRS and remove excess.

RT 10-10-20

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S10/10/27

**Work Order ID 62530**

October 4, 2010 9:20:13 AM

Page 5

Item ID: D212-805-011

Accept

Revision ID:

Item Name: Pod Modification Installation

Start Date: 10/04/10 Start Qty: 1.00

Required Date: 10/15/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

0.00



Small Fab

Memo

0.00

Small Fab

Install Radalt mounting plate assy as per dwg (Detail C) and bond doubler and shim with Sykaflex  
A/R Sykaflex Batch: 115114  
exp date: 11-01-01

RT 10-10-23

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/10/23

230

0.00



Small Fab

Memo

0.00

Small Fab

1- Using D4177-1 Radalt guard doubler to locate holes and spacing  
\*\*\*Drill from outside of pod to ensure location doesn't affect ribs on base\*\*\*  
2- Install parts seal and bond with sikaflex  
A/R Sykaflex Batch: 115114  
exp date: 11-01-01

RT 10-10-23

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Page 6

Item ID: D212-805-011

Accept

Revision ID:

Item Name: Pod Modification Installation

Setup Start

Stop

Start Date: 10/04/10 Start Qty: 1.00

Required Date: 10/15/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

8/10/10/25

QC

Memo

0.00

Quality Control

250

0.00

Small Fab

Memo

0.00

Small Fab

1- Locate D4172-041 mounting frame in base of pod as per dwg and use mounting frame to locate holes for inserts.  
2- Open holes to size.  
3- Pot insert as per dwg  
A/R Hysol Batch: 115680  
exp. date: 11-09-16  
4- Allow resin to cure then install mounting frame.

RT 10-10-22

260

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/10/10/27

**Work Order ID 62530**

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Page 7

Item ID: D212-805-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Pod Modification Installation

Start Date: 10/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212-601-142

Location:

PPP rev: PPP 60701

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

# Picklist Print

October 4, 2010 9:19:52 AM

Page 1

Work Order ID: 62530

Parent Item: D212-805-011

Parent Item Name: Pod Modification Installation



Start Date: 10/04/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.29 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4173-9		Manufactured	No				Each	3.0000	1	1			
---------	--	--------------	----	--	--	--	------	--------	---	---	--	--	--



Pod Radalt Seal

Location	Loc Qty	Loc Code
----------	---------	----------

ST	3	
----	---	--

62417

D4175-041		Manufactured	No			130	Each	2.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Pod GPS Doubler Assembly

Location	Loc Qty	Loc Code
----------	---------	----------

CA	2	
----	---	--

61883

D4174-1		Manufactured	No			170	Each	3.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Connector Plate

Location	Loc Qty	Loc Code
----------	---------	----------

CA	3	
----	---	--

61881

D4174-3		Manufactured	No			170	Each	3.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Connector Plate Doubler

Location	Loc Qty	Loc Code
----------	---------	----------

CA	3	
----	---	--

61882

RT 10-10-18

RT 10-10-18

RT 10-10-18

RT 10-10-18



# Picklist Print

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Page 2

Work Order ID: 62530

Parent Item: D212-805-011

Parent Item Name: Pod Modification Installation

Start Date: 10/04/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

170

Each

1,720.000

6

6



Nut

Location

Loc Qty

Loc Code

ST300

1720

114523

49

114784

1671

BT 10-10-18

x6

NAS1149D0363J

Purchased

No

170

Each

2,795.000

12

12



Washer

Location

Loc Qty

Loc Code

ST298

2795

114292

114

115107

25

115622

2647

9221

9

BT 10-10-18

x12

AN3-5A

Purchased

No

170

Each

1,457.000

6

6



Bolt

Location

Loc Qty

Loc Code

ST350

1457

105057

457

115016

500

115371

500

BT 10-10-18

x6

D4173-3

Manufactured

No

210

Each

3.0000

1

1



Pod Radalt Doubler

Location

Loc Qty

Loc Code

CA

3

61880

3

BT 10-10-18

x1

October 4, 2010 9:19:52 AM

Shop Packet Print

Page 2

# Picklist Print

October 4, 2010 9:19:52 AM

Page 3

Work Order ID: 62530

Parent Item: D212-805-011

Parent Item Name: Pod Modification Installation

Start Date: 10/04/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

D4173-7  
  
 Radalt Shim

Manufactured No 210 Each 1.0000 1 1



RT 10-10-18

Location Loc Qty Loc Code

CA	1	
61969	1	x1

D4173-041  
  
 Pod Radalt Mounting Plate Assembly

Manufactured No 210 Each 1.0000 1 1



Location Loc Qty Loc Code

CA	1	
61963	1	x1

RT 10-10-18

AN3-12A  
  
 Bolt

Purchased No 210 Each 114.0000 12 12



Location Loc Qty Loc Code

ST351	114	
114494	18	
114536	96	x12

RT 10-10-20

MS21042L3  
  
 Nut

Purchased No 210 Each 1,720.000 6 12



Location Loc Qty Loc Code

ST300	1720	
114523	49	
114784	1671	x12

RT 10 10 20

October 4, 2010 9:19:52 AM

Shop Packet Print

Page 3

# Picklist Print

October 4, 2010 9:19:53 AM

Page 4

Work Order ID: 62530

Parent Item: D212-805-011

Parent Item Name: Pod Modification Installation

Start Date: 10/04/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P Purchased

No

210

Each

567.0000

24

24



WASHER

Location

Loc Qty

Loc Code

ST275

567

18057

567

24

AN3-6A

Purchased

No

230

Each

226.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST351

226

113359

26

114941

200

4

NAS1149F0332P

Purchased

No

230

Each

567.0000

24

8



WASHER

Location

Loc Qty

Loc Code

ST275

567

18057

567

24

D4177-1

Manufactured

No

230

Each

4.0000

2

2



Radalt Guard Doubler

Location

Loc Qty

Loc Code

CA

4

61884

4

2

ST 10-10-24

ST 10-10-24

ST 10-10-24

ST 10-10-19

October 4, 2010 9:19:53 AM

Shop Packet Print

Page 4

# Picklist Print

October 4, 2010 9:19:54 AM

Page 5

Work Order ID: 62530

Parent Item: D212-805-011

Parent Item Name: Pod Modification Installation

Start Date: 10/04/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased No

230 Each

1,720.000 6 4



Nut

Location

Loc Qty

Loc Code

ST300

1720

114523

49

114784

1671

D3926-3

Manufactured No

230 Each

2.0000 2 2



Wedge

Location

Loc Qty

Loc Code

ST098

2

58851

2

D4172-041

Manufactured No

250 Each

0.0000 1 1



Pod Mounting Frame Assembly

80-005-3-8

Purchased No

250 Each

20.0000 8 8



Insert

Location

Loc Qty

Loc Code

ST379

20

115271

4

115669

16

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Shop Packet Print

Page 5

RT 10-10-20

xy

RT 10-10-20

xy

RT (10-10-2)

362432

RT 10-10-20

x8

# Picklist Print

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Page 6

Work Order ID: 62530

Parent Item: D212-805-011

Parent Item Name: Pod Modification Installation



Start Date: 10/04/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

AN4-4A Purchased

No

250

Each

186.0000

8

8x4



Bolt

Location

Loc Qty

Loc Code

ST356

183

114615

183

ST361

3

108138

2

111295

1

x4

ST 10-10-25

PHO

NAS1149F0432P Purchased

No

250

Each

290.0000

8

8



Washer

Location

Loc Qty

Loc Code

ST275

290

112940

92

114405

1

114576

10

114718

8

115698

179

x8

ST 10-10-25

October 4, 2010 9:19:55 AM

Shop Packet Print

Page 6

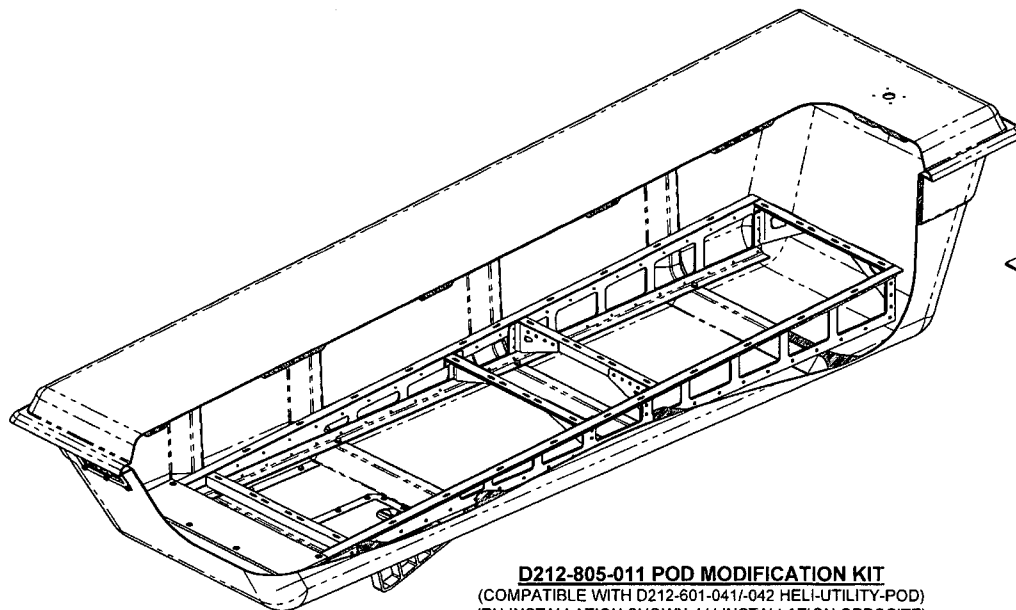
W/O: 62530		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-10-25	250	AN4-4A Bolts too short use AN4-7A x4 B 113226 PER NOTE 13 ON DWG.	RT	10-10-25		10/10/27 GSL042	8 10/10/27

Part No: D212-805-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D212-805-011 POD MODIFICATION KIT**  
(COMPATIBLE WITH D212-601-041/-042 HELI-UTILITY-POD)  
(RH INSTALLATION SHOWN, LH INSTALLATION OPPOSITE)

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 20 lbs APPROX
- 8) ENSURE D4175-041 WILL CLEAR D2200-1 LID FOAM CORE.  
USE DT9667 CUTOUT TEMPLATE TO FASTEN/BOND D4175-041 TO D2200-1 LID.  
REMOVE FASTENERS AND DT9667 TEMPLATE ONCE COMPLETELY CURED.
- 9) FOR INSTALLATION OF D4172-041 FRAME AND 80-005-3-8 INSERTS:
  - 9.1) LOCATE D4172-041 FRAME INSIDE POD SO THE FASTENER HOLES ARE MORE OR LESS ON THE CENTERLINE OF EACH D2200-3 POD RIBS;
  - 9.2) TRANSFER MARK AND DRILL SAME SIZE DIAMETER AS THE INSERT SHAFT DIAMETER TO A MAXIMUM OF 1.250" DEEP;
  - 9.3) CLEAN OUT FOAM CORE Ø0.125" TO 0.250" AROUND HOLE BETWEEN OUTER AND INNER SKINS;
  - 9.4) FOR EACH CAVITY, FILL ONE THIRD WITH "HYSOL EA394" OR EQUIVALENT EPOXY COMPOUND;
  - 9.5) INSTALL 80-005-3-8 INSERTS BY FILLING THE CAVITY WITH "HYSOL EA394" PER QSI 006 14.6 ENSURING INSIDE OF INSERTS ARE FREE OF POTTING COMPOUND;
  - 9.6) GRIND TO A SMOOTH SURFACE AS REQUIRED AFTER EPOXY HAS COMPLETELY CURED;
  - 9.7) TOUCH UP FINISH USING DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S.
- 10) TRANSFER DRILL HOLES IN POD AND D4177-1 DOUBLERS TO D3926-3 WEDGES PRIOR TO FASTENING D3926-3 TO POD.
- 11) SEAL EDGES OF ALL DRILLED HOLES AND CUTOUTS WITH CYANOACRYLATE GLUE (CRAZY GLUE)
- 12) WET INSTALL D3926-3, D4173-3/-7, D4174-1/-3, D4175-041, D4177-1 USING SIKAFLEX -241/-291 ADHESIVE
- 13) IT IS ACCEPTABLE TO USE LONGER AN4 BOLTS AND INSERT SHIMS AS REQUIRED BETWEEN THE POD RIBS AND D4172-041 FRAME.  
MANUFACTURE 1.00" X 1.00" SHIMS TO REQUIRED THICKNESS FROM M6061T6S OR M6061T6B ALUMINUM.

ITEM	QTY. -011	P/N	DESCRIPTION
	X	D212-805-011	POD MODIFICATION KIT
12	1	D3926-3	WEDGE
	2	D4172-041	POD MOUNTING FRAME ASSY
	3	D4173-041	POD RADALT MOUNTING PLATE ASSY
12	4	D4173-3	POD RADALT DOUBLER
12	5	D4173-7	RADALT SHIM
	6	D4173-9	POD RADALT SEAL
12	7	D4174-1	CONNECTOR PLATE
12	8	D4174-3	CONNECTOR PLATE DOUBLER
8	9	D4175-041	POD GPS DOUBLER ASSY
12	10	D4177-1	RADALT GUARD DOUBLER
9	11	80-005-3-8	POTTED INSERT
	12	AN3-5A	BOLT
	13	AN3-6A	BOLT
	14	AN3-12A	BOLT
13	16	AN4-4A	BOLT
	17	MS21042L3	NUT
	18	NAS1149D0363J	WASHER
	19	NAS1149F0332P	WASHER
	20	NAS1149F0432P	WASHER
13	21	A/R N/A	SHIM

CX10/10/19  
W10:62530

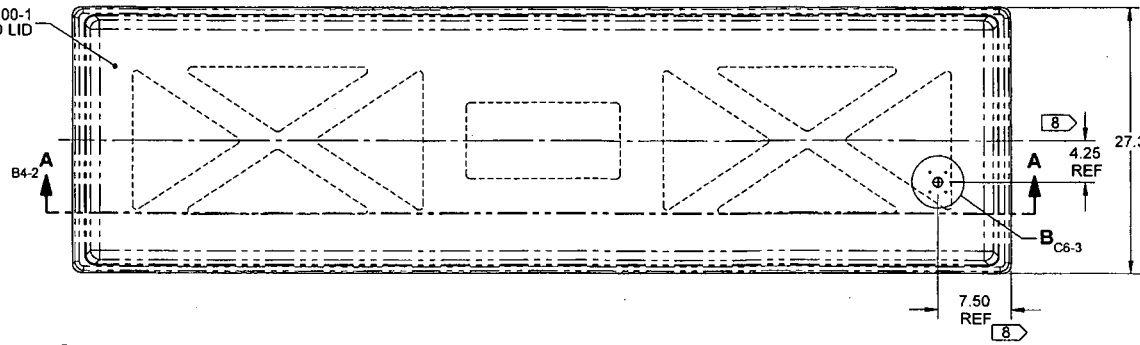
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2010-09-29

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APPROVED			
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DATE	10.09.13		

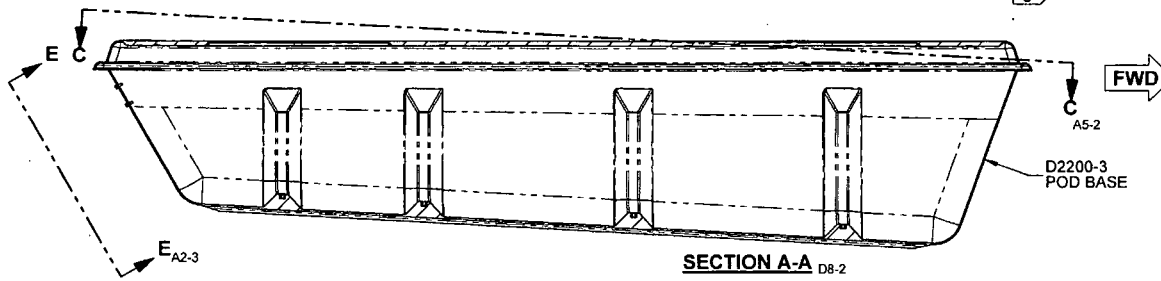
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HAWKESBURY, ONTARIO, CANADA	
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D212-805	SHEET 1 OF 5
TITLE	SCALE
POD MODIFICATION KIT	NTS
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D2200-1  
POD LID



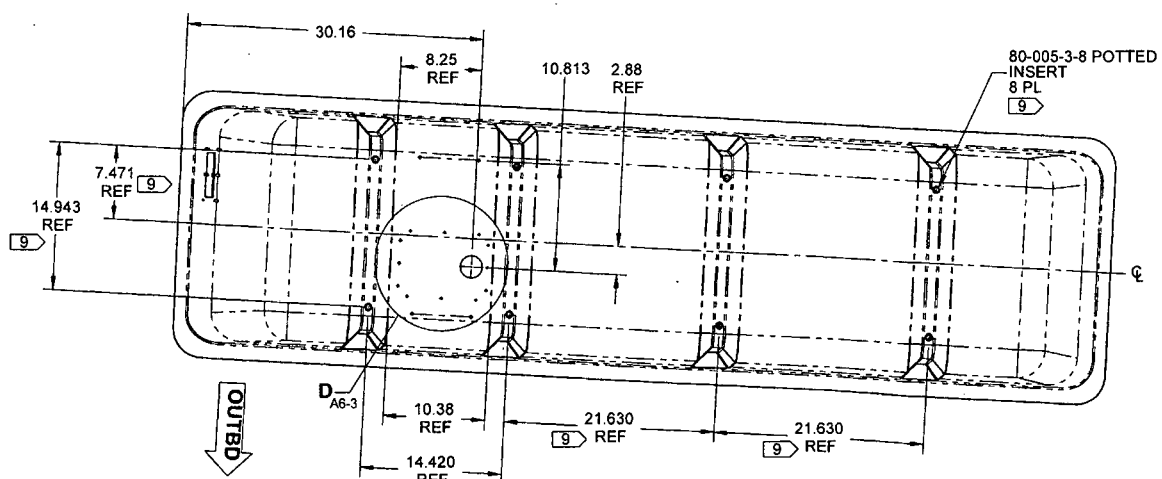
OUTBD



FWD

D2200-3  
POD BASE

W10.6 2530



80-005-3-8 POTTED  
INSERT  
8 PL

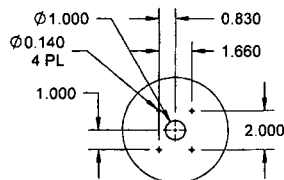
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LID NOT SHOWN

RELEASED  
2010-09-29

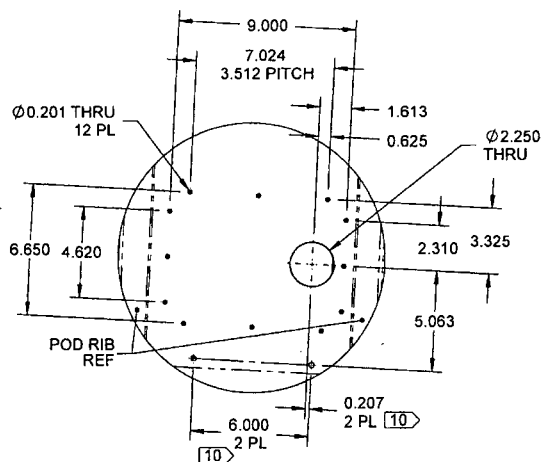
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D212-805	REV. A
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		POD MODIFICATION KIT	NTS
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8 7 6 5 4 3 2 1

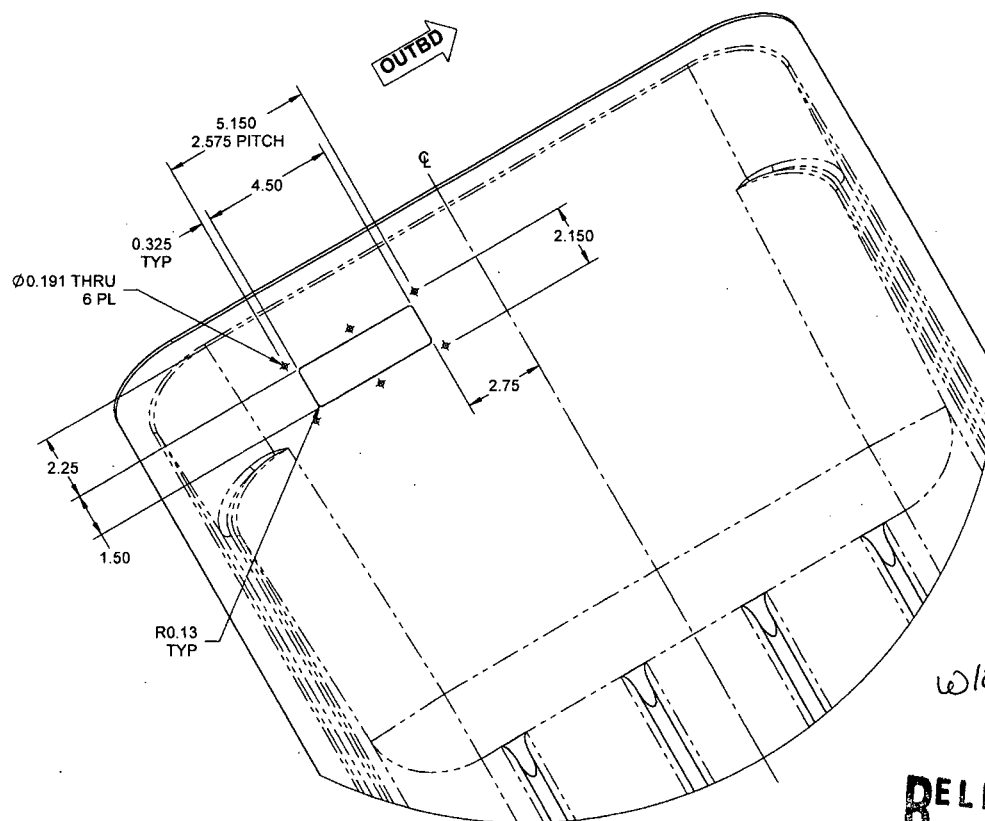




**DETAIL B: GPS MOUNT HOLE PATTERN** D3-2  
(TRANSFER DRILL HOLE PATTERN TO POD LID USING D19667 TEMPLATE)  
SCALE 2X 8



**DETAIL D: RADALT MOUNTING PLATE HOLE PATTERN** A7-2  
(TRANSFER DRILL HOLE PATTERN TO POD BASE USING D19669 TEMPLATE)  
SCALE 2X 10

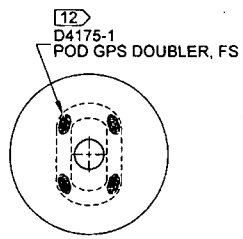
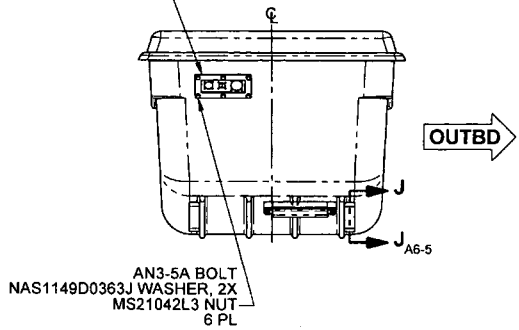
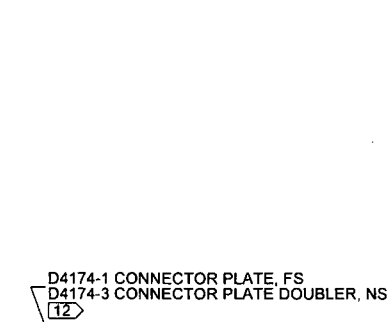


**VIEW E-E: CONNECTOR PLATE HOLE PATTERN** B7-2  
(TRANSFER DRILL HOLE PATTERN TO POD BASE USING D19668 TEMPLATE)  
SCALE 3X

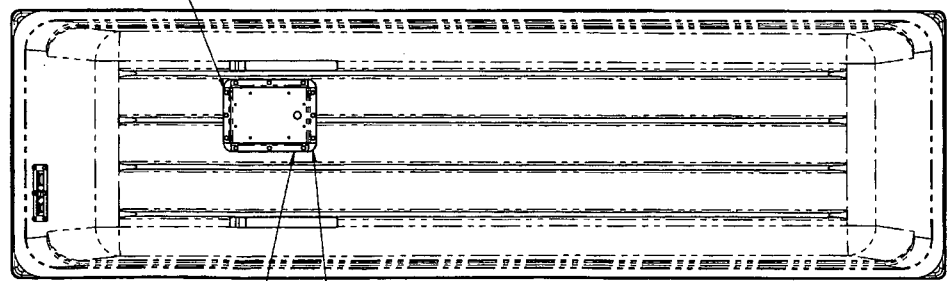
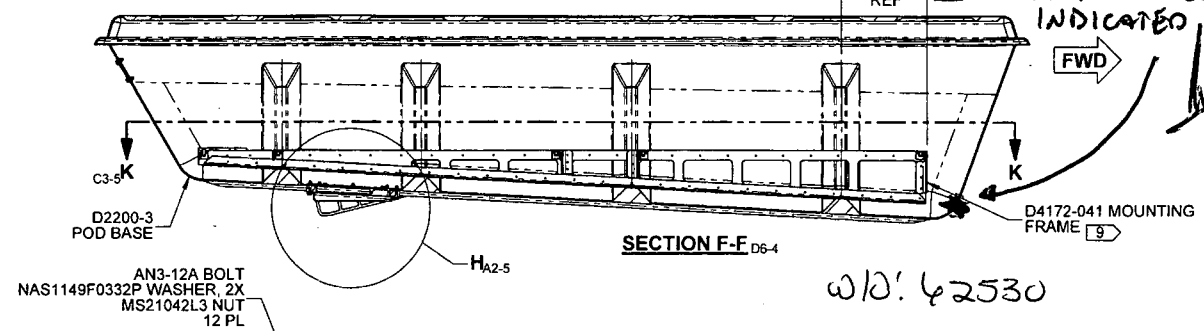
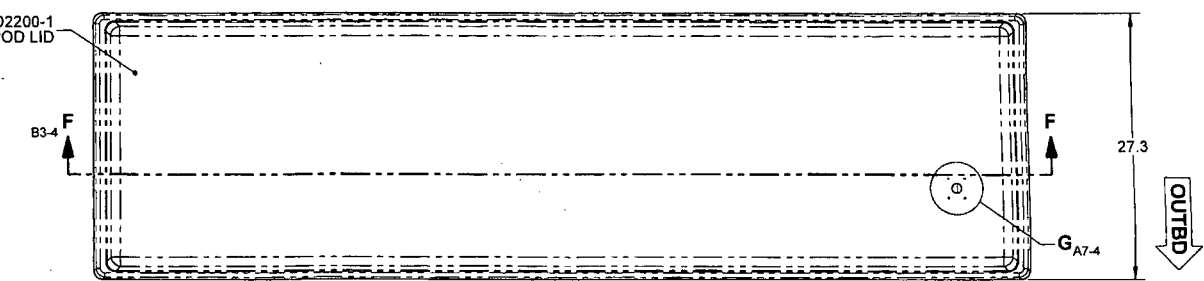
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7.6



DETAIL G  
SCALE 2X D1-4



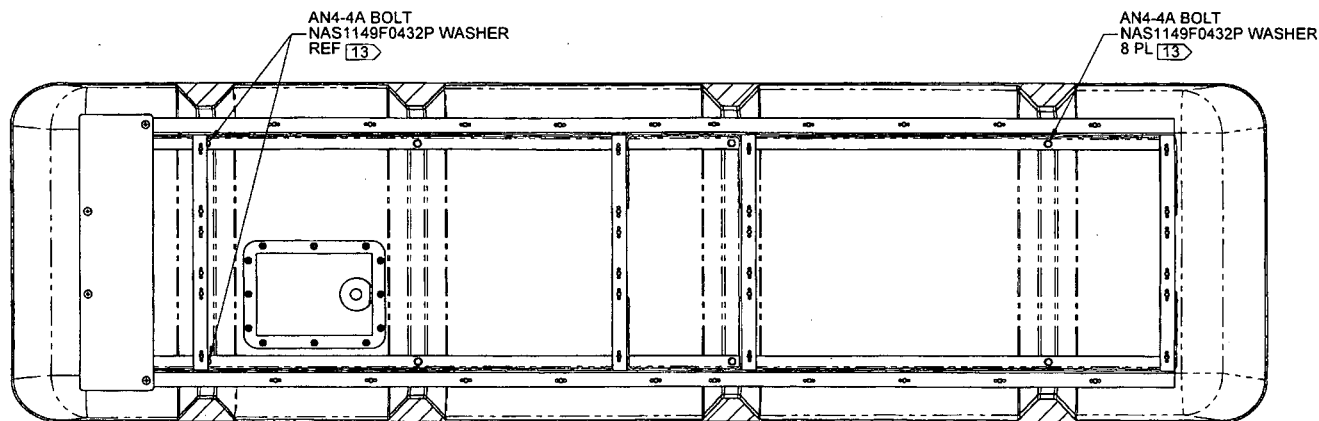
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INDICATED

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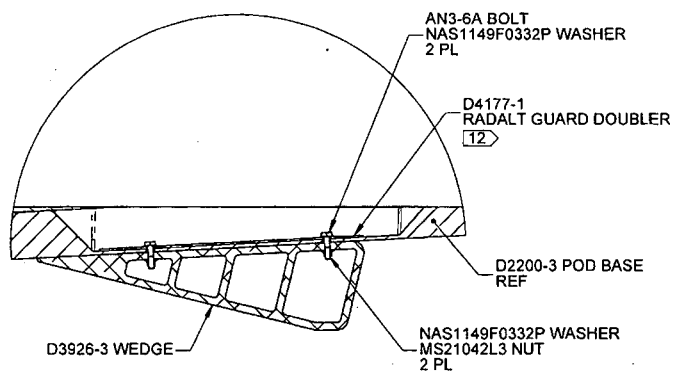
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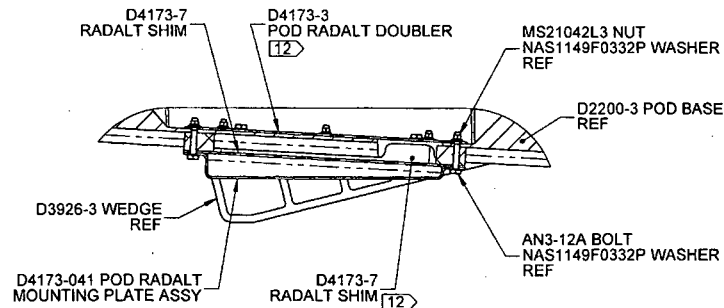
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**SECTION K-K: D4172-041 POD FRAME INSTALLATION** C5-4  
SCALE 1.5X



**SECTION J-J: RADALT GUARD INSTALLATION** B7-4  
SCALE 3X, 2 PL PER POD 10



**DETAIL H: RADALT MOUNTING PLATE INSTALLATION** B4-4  
SCALE 3X

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